

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017978**Date Inspected:** 19-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG COMPONENT				

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

**Magnetic Particle Testing (MPT) for OBG CB16**

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG crossbeam CB16 weld. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

**The Weld Designations are as follows**

CB202D-001-002

CB202A-016-005,011

FB204-049-061,062,067,068,026,044

FB204-050-061,062,067,068,026,044

FB204-051-061,062,067,068,026,044

FB204-052-061,062,067,068,026,044

CB202G-049-109,110,182,183,111,112,113,114,053,054,055,056,148,166,133,134,135,136,137,138

CB202G-050-109,110,182,183,111,112,113,114,053,054,055,056,148,166,133,134,135,136,137,138

CB202G-051-109,110,182,183,111,112,113,114,053,054,055,056,148,166,133,134,135,136,137,138

CB202G-052-109,110,182,183,111,112,113,114,053,054,055,056,148,166,133,134,135,136,137,138

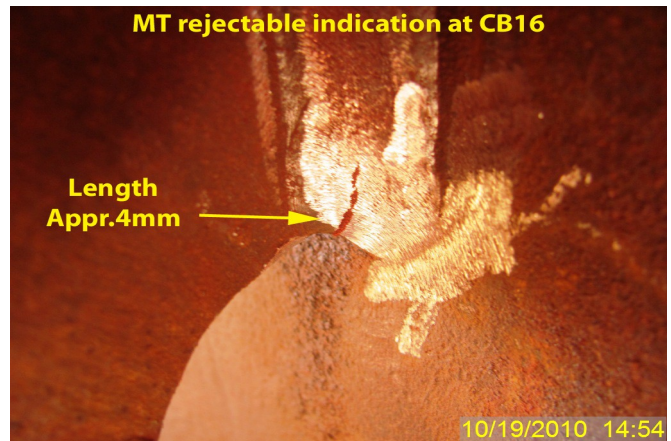
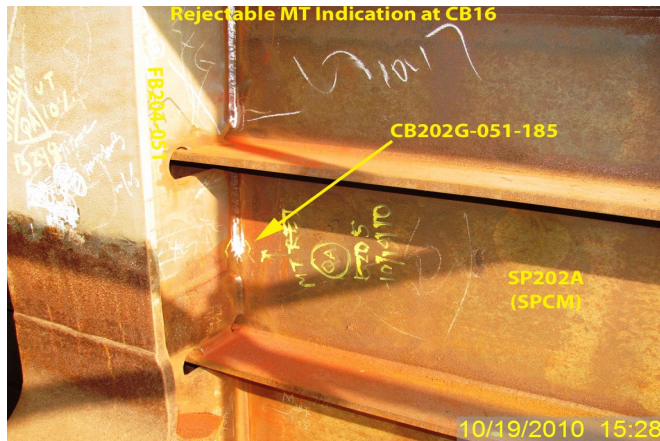
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During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Orthotropic Box Girder (OBG) Cross Beam CB16, this Quality Assurance Inspector (QA) discovered the following issues: Two (2) Longitudinal Linear indications in welds identified as CB202G-051-185 & CB202G-049-185. For Weld CB202G-051-185 the Longitudinal Linear indication measuring approximately 4mm. Y location is 0mm from the Side panel (SP202A). Weld CB202G-051-185 is a Fillet Weld joining Floor Beam Intermediate Diaphragm FB204-051 to Side Panel SP202A. SP202A is designated as SPCM.

And Weld CB202G-049-185 the Longitudinal Linear indication measuring approximately 8mm. Y location is 0mm from the Side panel (SP202A). Weld CB202G-049-185 is a Fillet Weld joining Floor Beam Intermediate Diaphragm FB204-049 to Side Panel SP202A. SP202A is designated as SPCM. OBG Cross Beam CB16 is located near the North end of bay 19. The Notice of Witness Inspection Number (NWIT) is 07010. Welds CB202G-051-185 & CB202G-049-185 are within an area previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform 100% MT inspection of these welds. This QA inspector informed to other QA Mr. Sukanthan to generate an incident report on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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